

Work Order ID 163512

Tuesday, June 27, 2017 1:28:15 PM

163512

Page 1

Item ID: D3259-041

Revision ID:

Item Name: Access Panel Assembly LH

Start Date: 6/27/2017 Start Qty: 2.00

Required Date: 7/3/2017 Req'd Qty: 2.00

Reference:

Accept

N900040100Setup Start ***NS1***Stop ***NS2***

Cust Item ID:

Customer:

Approvals: Process Plan: **DAS 21 9-89** Date: **JUN 28 2017**

Tooling: Date:

Run Start ***NR1***QC: **DAS 21 9-89** Date: SPC (Y/N): Date:Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D3259	Rev B

100 Pick Kit 0.00

100

Packaging Memo 0.00

Packaging

110 Small Fab 0.00

110

Small Fab Memo 1.35

Small Fab Assemble D3259-041 as per Dwg D3259.

Note:Keep .040" Gap all around door.

120 QC5- Inspect part completeness to step on W/O 0.00

120

QC Memo 0.04

Quality Control

2 **DAS 21 9-89** **AUG 03 2017****3x** **DAS 36 9-89** **17/0/0****3** **DAS 38 9-89** **AUG 14 2017**

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE



QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval		
Description Work Order Deviation				Disposition				Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY							
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐				
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐				
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐				
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐				
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐				
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐				
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐				
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐				
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐				
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐				
Past Expiry Date ☐	Manufacturing Process ☐								
Misidentified ☐	Past Due ☐								
OTHER : ☐									

Work Order ID 163512

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Item ID: D3259-041 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Access Panel Assembly LH
Start Date: 6/27/2017 Start Qty: 2.00 ***2*** Cust Item ID:
Required Date: 7/3/2017 Req'd Qty: 2.00 ***2*** Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 *130* Packaging Packaging	Identify as per dwg & Stock Location: <i>ST491</i> Memo	0.00 0.02				<i>3</i>	<i>AUG 17 2017</i>		<i>rf</i>
140 *140* QC Quality Control	QC21- Final Inspection - Work Order Release Memo	0.00 0.20							<i>17/9/5</i>

UM 17/8/18 **DAS 21 9-89**

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WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

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Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐																																																													
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Misidentified ☐	Past Due ☐																																																																

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Work Order ID: 163512

163512

Parent Item: D3259-041

D3259-041

Parent Item Name: Access Panel Assembly LH

Start Date: 6/27/2017

Required Date: 7/3/2017

Start Qty: 2.00

Required Qty: 2.00

Comments: IPP Rev:A New Issue 07-07-19 JLM Verified By:EC IPP REV
B:AS PER REV B 10-05-19 JLM VERIFIED BY:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D3161-5 *D3161-5* Hinge 9.9"		Manufactured	No			110	Each	6.0000	1	23		AUG 09 2017	DAS 6 9-89
				<u>Location</u>				<u>Loc Qty</u>					
				ST483				6					
				151737				2					
				159026				4					
D3259-1 *D3259-1* Panel		Manufactured	No			110	Each	2.0000	1	23		AUG 09 2017	DAS 6 9-89
				<u>Location</u>				<u>Loc Qty</u>					
				ST490				2					
				151766				2					
D3259-3 *D3259-3* Doubler		Manufactured	No			110	Each	6.0000	1	2		AUG 09 2017	DAS 6 9-89
				<u>Location</u>				<u>Loc Qty</u>					
				ST490				6					
				142736				2					
				151749				4					
D3259-5 *D3259-5* Spacer		Manufactured	No			110	Each	7.0000	1	23		AUG 09 2017	DAS 6 9-89
				<u>Location</u>				<u>Loc Qty</u>					
				ST490				7					
				148604				1					
				158833				6					

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Environment ☐	Design ☐	Doc/Data ☐	Equip/Tooling ☐	Handling/Pre ☐	Material ☐	Internal Transport ☐	Tribal Knowledge ☐	LOA ☐	Substation ☐	Past Expiry Date ☐	Misidentified ☐	No Re-verification ☐	Operator ☐	Offset/Setup ☐	Supplier ☐	Training ☐	Use for Testing ☐	Poor Information ☐	Rushing ☐	Product Improvement ☐	Process Improvement ☐	Manufacturing Process ☐	Past Due ☐	Pressure/Forced ☐	Bending ☐	Centre Not Concentric ☐	Cracks ☐	Crimp/Kink/Ripple/Wave ☐	Cuffs ☐	Crushing ☐	Heat Treat ☐	Wave/Twist in Tube ☐	Marks/Chatter ☐	Temperature/Cure ☐	Set-up ☐	BOM/Route ☐	Broken/Damage/Defect ☐	Inspection Incomplete/Unqualified ☐	Contamination ☐	Countersink ☐	Cut Too Short ☐	Instructions Incomplete/Unclear ☐	Drill Holes ☐	Power Loss/Surge ☐	Folio/Program ☐	Grain ☐	Weld ☐	Wrong Stock Pulled ☐	Out of Sequence ☐	Off-set ☐	Mislabeled ☐	Fit/Function ☐	Misaligned/off center ☐	Positioned Wrong ☐	Outside Dimensions ☐	Over/Under tolerance ☐	Part Incorrect ☐	Part Lost/Missing ☐	Part Moved ☐	Drawing ☐	Finish ☐	Misread ☐	Turning Sequence ☐
																								OTHER : ☐																																							

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Work Order ID: 163512

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Parent Item: D3259-041

D3259-041

Parent Item Name: Access Panel Assembly LH

Start Date: 6/27/2017

Required Date: 7/3/2017

Start Qty: 2.00

Required Qty: 2.00

D3259-7
D3259-7
Door

Manufactured No

110 Each 6.0000 1
**

23

DAS
6
9-89

AUG 09 2017

Location	Loc Qty	Loc Code
ST490	6	
159094	6	

2

D3260-1
D3260-1
Spring

Manufactured No

110 Each 31.0000 2
**

46

DAS
6
9-89

AUG 09 2017

Location	Loc Qty	Loc Code
ST028	31	
148642	9	
159144	22	

6

D3972-5
D3972-5
Grommet, Half, Dzus

Manufactured No

110 Each 50.0000 2
**

46

DAS
6
9-89

AUG 09 2017

Location	Loc Qty	Loc Code
ST063	50	
98113	50	

6

D3973-5
D3973-5
Receptable, Rigid, Dzus

Manufactured No

110 Each 12.0000 2
**

46

DAS
6
9-89

AUG 09 2017

Location	Loc Qty	Loc Code
ST063	12	
112405	8	
148179	4	

4

2x B164861

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Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval		
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								Lead hand / Supervisor Approval Verification	
Root Cause		FAULT CATEGORY							
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐	Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐	Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐				
OTHER : ☐									

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Work Order ID: 163512

163512

Parent Item: D3259-041

D3259-041

Parent Item Name: Access Panel Assembly LH

Start Date: 6/27/2017

Required Date: 7/3/2017

Start Qty: 2.00

Required Qty: 2.00

D3974-20 Manufactured No

110 Each 95.0000 2

D3974-20

Stud, Wing Head, 5/16 Dzus

**

DAS
6 AUG 09 2017
9-89

Location

Loc Qty

Loc Code

ST063

95

112543

19

115316

75

58761

1

MS20426AD4-4 Purchased No

110 Each 2,520.000 4

MS20426AD4-4

Rivet

**

DAS
17/08/10
36
9-89

Location

Loc Qty

Loc Code

GA

1041

125445

1041

ST312

1479

m132536

1479

MS20470AD3-4 Purchased No

110 Each 4,888.000 36

MS20470AD3-4

Rivet, Universal Head

**

DAS
17/08/10
36
9-89

Location

Loc Qty

Loc Code

GA

1031

m136851

1031

ST310

3857

m136665

3857

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WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

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Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date : _____	Step #: _____	QTY Effective : _____		MRB (QSI042) Approval	
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				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐			
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Work Order ID: 163512

163512

Parent Item: D3259-041

D3259-041

Parent Item Name: Access Panel Assembly LH

Start Date: 6/27/2017

Required Date: 7/3/2017

Start Qty: 2.00

Required Qty: 2.00

MS20470AD3-5

Purchased

No

110

Each

3,060.000

10

~~20~~ 30

MS20470AD3-5

**

17/08/10
DAS
36
9-89

Rivet, Solid Universal Head

Location

Loc Qty

Loc Code

GA

1202

9682

1202

ST310

1858

9682

1858

30

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